

Date: Friday, 5/25/2007 8:26:15 AM  
User: Kim Johnston

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE, INBOARD, RS, 206		
Job Number	: 32625						
Estimate Number	: 10821						
P.O. Number	:			Part Number	: D26662		
This Issue	: 5/25/2007	S.O. No.	:	Drawing Number	: D2666 REV.D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: D		
Previous Run	: 31299			Material	:		
Written By	:			Due Date	: 6/30/2007	Qty:	10
Checked & Approved By	: <u>John</u> 07.05.28			Um:	Each		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house						
	processEC						
	Est Rev:D As per Rev D 07-03-19 JLM						

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length	Batch No: <u>B31386</u> <span style="float: right;">07-09-25 (10)</span>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly.  3-Fixturing Inspection last completed on <u>N/A</u> by <u>N/A</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr	<span style="float: right;">BG 07-09-26 (10)</span>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
	Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<span style="float: right;">BG 07-09-26 (10)</span>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<span style="float: right;">BG 07-09-26 (10)</span>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 32625

Part Number: D26662

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 07/09/26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(10x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L

07/09/27

7.0 POWDER COATING POWDER COATING



(10)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 07-09-28

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/09/01

(10)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

82526

PL 7/10/01

(10)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



07.10.01 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/09/01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32625
Description: 206 Saddle, Inboard, Right side				Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.127	.127	.127		
B	0.100	0.140		.121	.121	.121	.121		
C	2.470	2.510		2.496	2.496	2.496	2.496		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.227	.227	.227	.227		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.260	.255	.255	.255		
H	0.615	0.685		.640	.640	.640	.640		
I	1.125	1.145		1.132	1.132	1.132	1.132		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.117	.117	.117	.117		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.565	.565	.555	.555		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>RG</i>	Audited by:	<i>JL</i>
Date:	07/09/25	Date:	07/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>JK</i>	<i>JK</i>

DART AEROSPACE LTD				Work Order: 32625	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.127	.127	.127	.127		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.496	2.496	2.496	2.496		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.226	.226	.226	.226		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.255	.255	.255	.255		
H	0.615	0.685		.640	.640	.640	.640		
I	1.125	1.145		1.137	1.137	1.137	1.137		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.117	.117	.117	.117		
N	1.565	1.585		.115	.115	.115	.115		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.556	.556	.556	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SG	Audited by:	JL
Date:	07-09-25	Date:	07/09/26

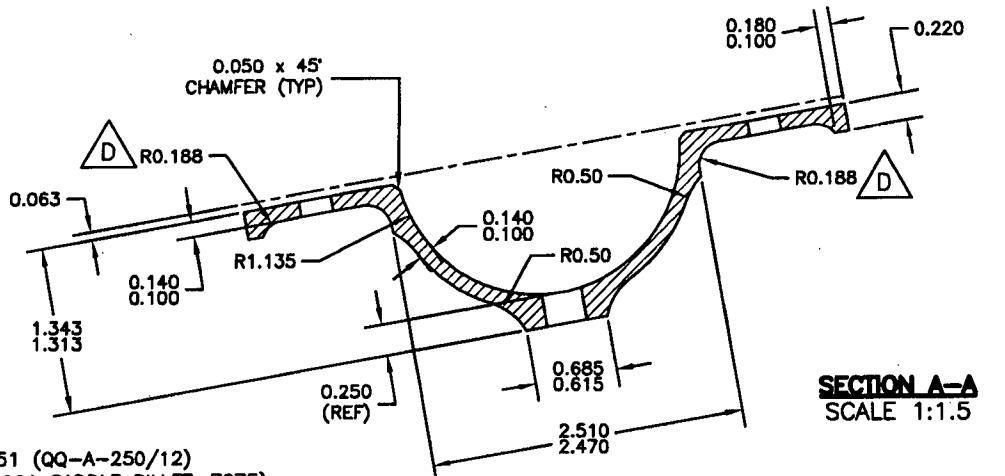
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO.	REV. D
		D2666	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.08		SADDLE FWD INSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

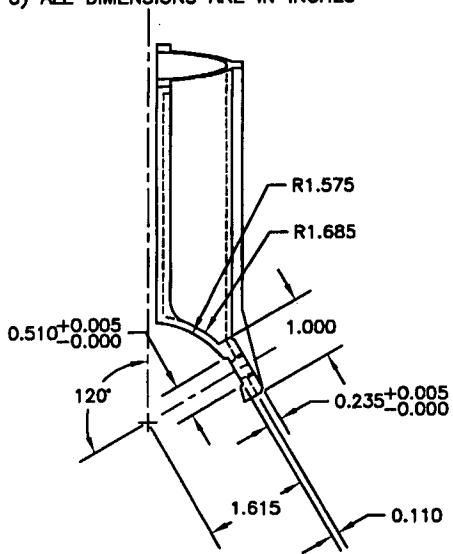
RELEASED

07.02.12 *PH*



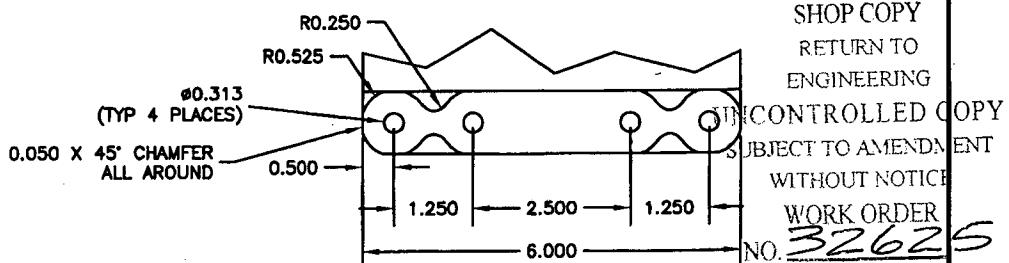
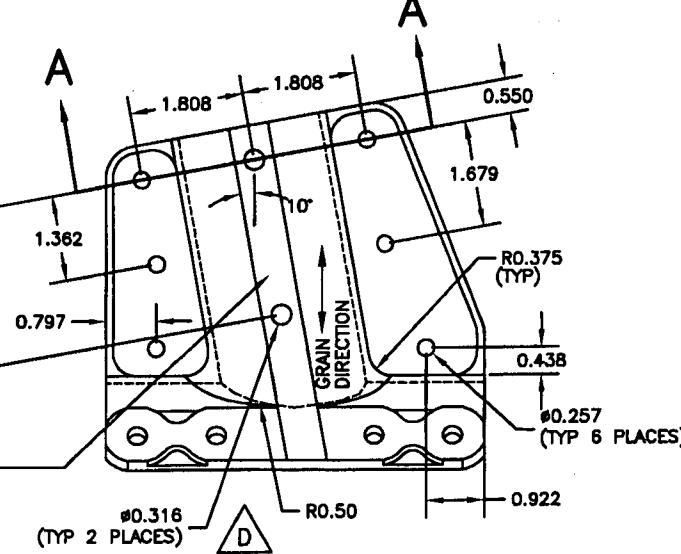
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH

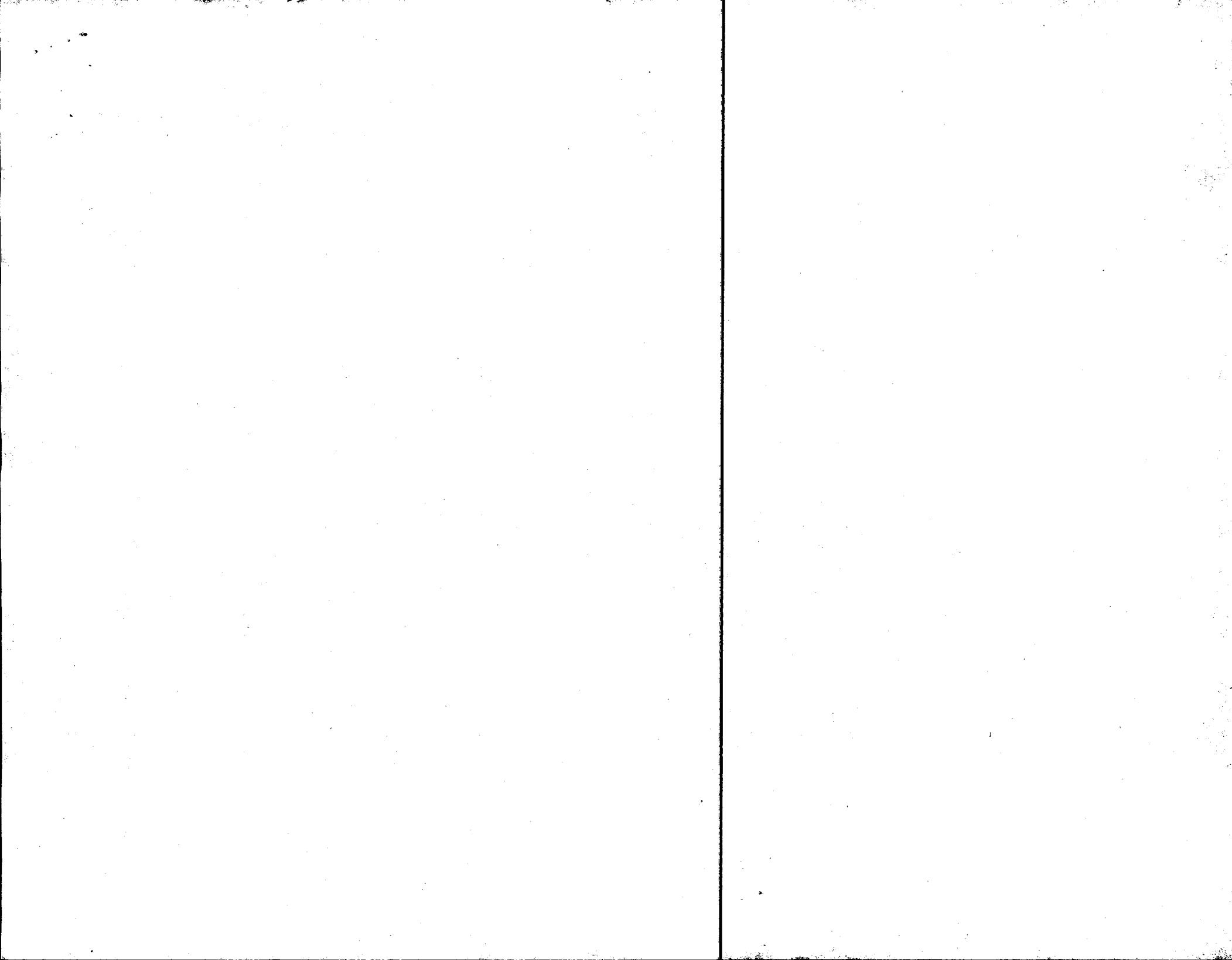
ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32625

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DART AEROSPACE LTD	Work Order:	<u>34781</u> <u>32625</u>
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dir	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125				
B	0.100	0.140		.120	.120				
C	2.470	2.510		2.497	2.497				
D	0.100	0.180		.140	.140				
E	0.210	0.230		.226	.226				
F	1.313	1.343		1.330	1.330				
G	0.240	0.260		.255	.255				
H	0.615	0.685		.640	.640				
I	1.125	1.145		1.138	1.138				
J	0.990	1.010		1.000	1.000				
K	0.235	0.240		.239	.239				
L	0.510	0.515		.510	.510				
M	0.100	0.120		.116	.116				
N	1.565	1.585		1.575	1.575				
O	5.990	6.010		6.010	6.010				
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Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.507	.507				
S	0.313	0.318		.314	.314				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.315	0.322		.319	.319				
W	0.540	0.560		.556	.556				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.178	0.198		.188	.188				
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AD									
AE									
AF									
Accept/Reject									

Measured by:	<u>JK</u>	Audited by:	<u>JL</u>
Date:	07-04-26	Date:	07/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	09.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	09.11.10	Added Dim. R-T	RF	
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